

Date: Wednesday, 3/26/2008 9:54:30 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CONSOLE ASSEMBLY 407
Job Number : 38185	
Estimate Number : 11720	
P.O. Number :	Part Number : D407547047
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D206-547 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : SMALL /MED FAB	Drawing Revision : F
Previous Run : 35491	Material :
Written By :	Due Date : 4/4/2008 Qty: <u>10</u> Um: Each
Checked & Approved By : <u>JD 08.3.27</u>	
Comment : Est Rev: 06-01-05 Removed Packing Kit JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2024	Extrusion, Console
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Comment: Qty.: 3.5910 Each(s)/Unit Total: ~~14.3640~~ Each(s)
 D2024 Extrusion 35.910
 Batch M1

FF 08-04-03

(10)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, DT 8264-2, DT8264-3, DT8264-4

2-Deburr

FF 08-04-03

(10)

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

8 08/04/09 (410)

4.0	D26041	407 Hi Console Side LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~4.0000~~ Each(s)
 Pick: 10.000

Qty Part Number	Description	Batch
1 D2604-1	Side LH	<u>B38264</u>

FF 08-04-08

(10)

5.0	D26042	407 Hi Console Side RH
-----	--------	------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~4.0000~~ Each(s)
 Pick: 10.000

Qty Part Number	Description	Batch
1 D2604-2	Side RH	<u>B38265</u>

FF 08-04-08

(10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:54:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 38185

Part Number: D407547047

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0

D2606

Hi Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~4.0000~~ Each(s)
10.000

Pick:

Qty Part Number

Description

Batch

1 D2606

Bracket

~~B 36081~~
~~B 36081~~

FF 08-04-14

(10)

7.0

D2608

407 Console Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: ~~4.0000~~ Each(s)
10.000

Pick:

Qty Part Number

Description

Batch

1 D2608

Bracket

~~B 17357~~
~~B 17357~~

~~B 36081~~

~~B 36081~~

FF 08-04-14

(10)

8.0

MS20470AD33

Rivet, Universal Head



Comment: Qty.: 6.0000 Each(s)/Unit Total: ~~24.0000~~ Each(s)
60.000

Pick:

Qty Part Number

Description

Batch

6 MS20470AD3-3

Rivet

~~B 17357~~
~~B 17357~~

FF 08-04-14

(10)

9.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 20.0000 Each(s)/Unit Total: ~~80.0000~~ Each(s)
200.000

Pick:

Qty Part Number

Description

Batch

20 MS20470AD3-4

Rivet

~~B 17357~~
~~B 17357~~

FF 08-04-14

(10)

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Grind weld relief chamfer as per Dwg D206-547

2-Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4

FF 08-04-14

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:54:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 38185

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/14 (X10)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D206-547

A/R AL ROD Batch: M404855

2-Grind weld as per dwg D206-547

08-05-8 SP.

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/05/13 (X10)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3

PF 08-05-20 (10)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/20 (X10)

30 min

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M105642

M-1

08/

21/05/2008
S.264 07.52
#1 321/4 F
#2 338/85 F
#3 174/547 F
#4

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/05/21 (10)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PPP. #38166

08/05/23 (X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:54:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE ASSEMBLY 407

Job Number: 38185

Part Number: D407547047

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/27

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED KE	DRAWING NO. D206-547	REV. F SHEET 1 OF 5
DATE 99.02.11		TITLE CONSOLE ASSEMBLY	SCALE NTS
-	82.11.23	NEW ISSUE	
A	83.01.18	REDRAWN, ADD NOTE 4	
B	84.10.23	D206-547 WAS 01.8.81.017	
C	89.03.30	REDRAWN	
D	90.12.06	COMPANY NAME CHANGE MS20470 WAS MS20426 DIM 1.312 WAS 1.0, 13.160 WAS 12.85	
E	97.10.22	REDRAWN, ADD -043, -045, -047	
F	99.02.11	ADD MS20470AD3-3 RIVET (NC 143) UPDATED WELD DETAIL	

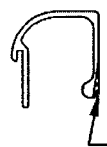
RELEASED
99.03.05 RE

-041	-043	-045	-047	PART NUMBER	DESCRIPTION
X				D206-547-041	CONSOLE ASSEMBLY
	X			D206-547-043	CONSOLE ASSEMBLY
		X		D407-547-045	CONSOLE ASSEMBLY
			X	D407-547-047	CONSOLE ASSEMBLY
1				D2601-1	CONSOLE SIDE
1				D2601-2	CONSOLE SIDE
	1			D2602-1	CONSOLE SIDE
	1			D2602-2	CONSOLE SIDE
		1		D2603-1	CONSOLE SIDE
		1		D2603-2	CONSOLE SIDE
			1	D2604-1	CONSOLE SIDE
			1	D2604-2	CONSOLE SIDE
1		1		D2605	CONSOLE BRACKET
	1		1	D2606	CONSOLE BRACKET
1	1			D2607	CONSOLE BRACKET
		1	1	D2608	CONSOLE BRACKET
1		1		D2709-1	CONSOLE SIDE RAIL
1		1		D2709-2	CONSOLE SIDE RAIL
1		1		D2709-3	CONSOLE SIDE RAIL
1		1		D2709-4	CONSOLE SIDE RAIL
	1		1	D2710-1	CONSOLE SIDE RAIL
	1		1	D2710-2	CONSOLE SIDE RAIL
	1		1	D2710-3	CONSOLE SIDE RAIL
	1		1	D2710-4	CONSOLE SIDE RAIL
10	8	8	6	MS20470AD3-3	RIVET
18	20	18	20	MS20470AD3-4	RIVET

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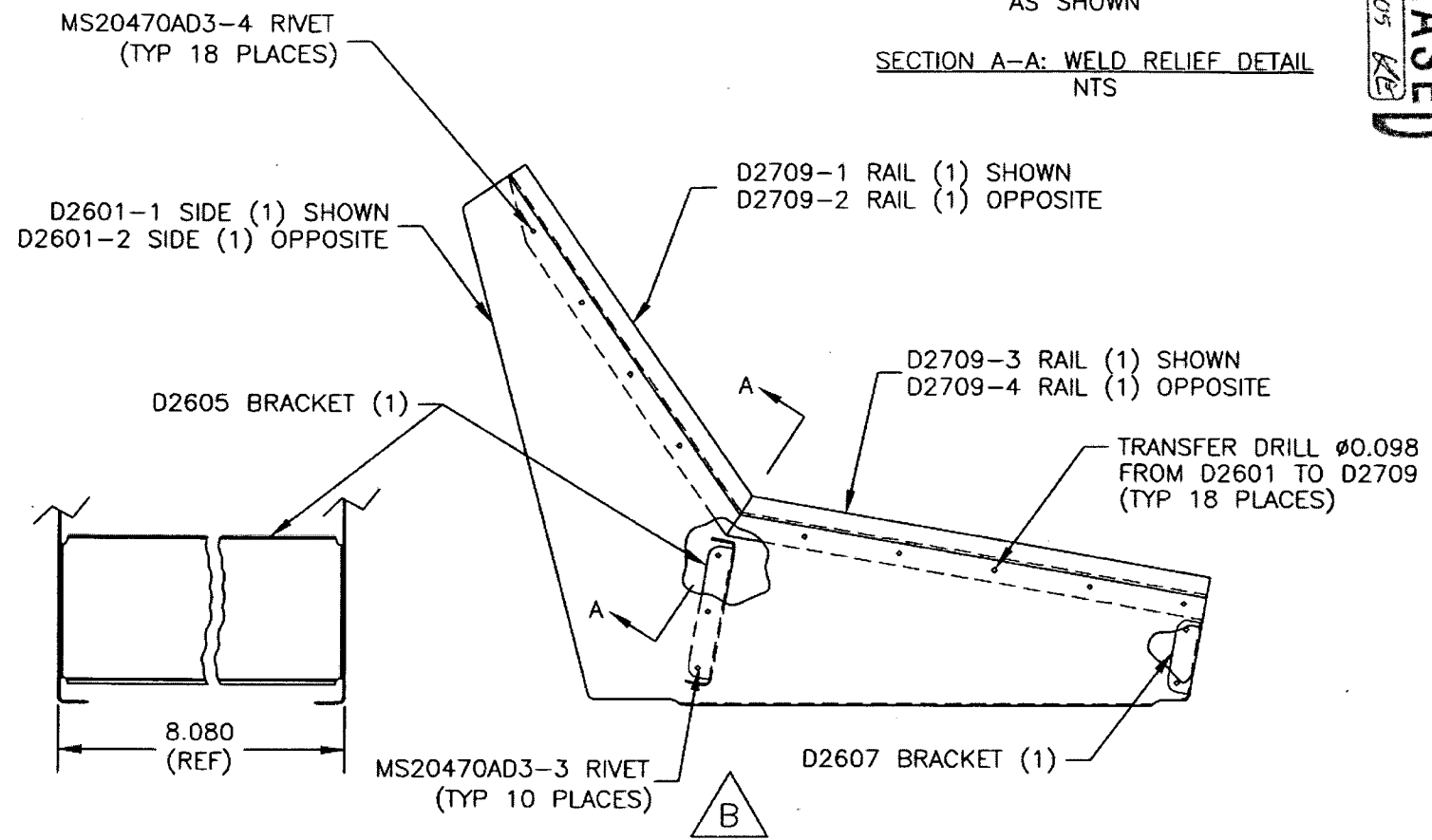
DART

RELEASED
99.03.05 KE



GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED JP	APPROVED KE	DRAWING NO. D206-547
DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 2 OF 5
		SCALE 1:4

D206-547-041 (206 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

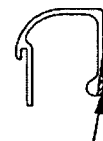
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DART

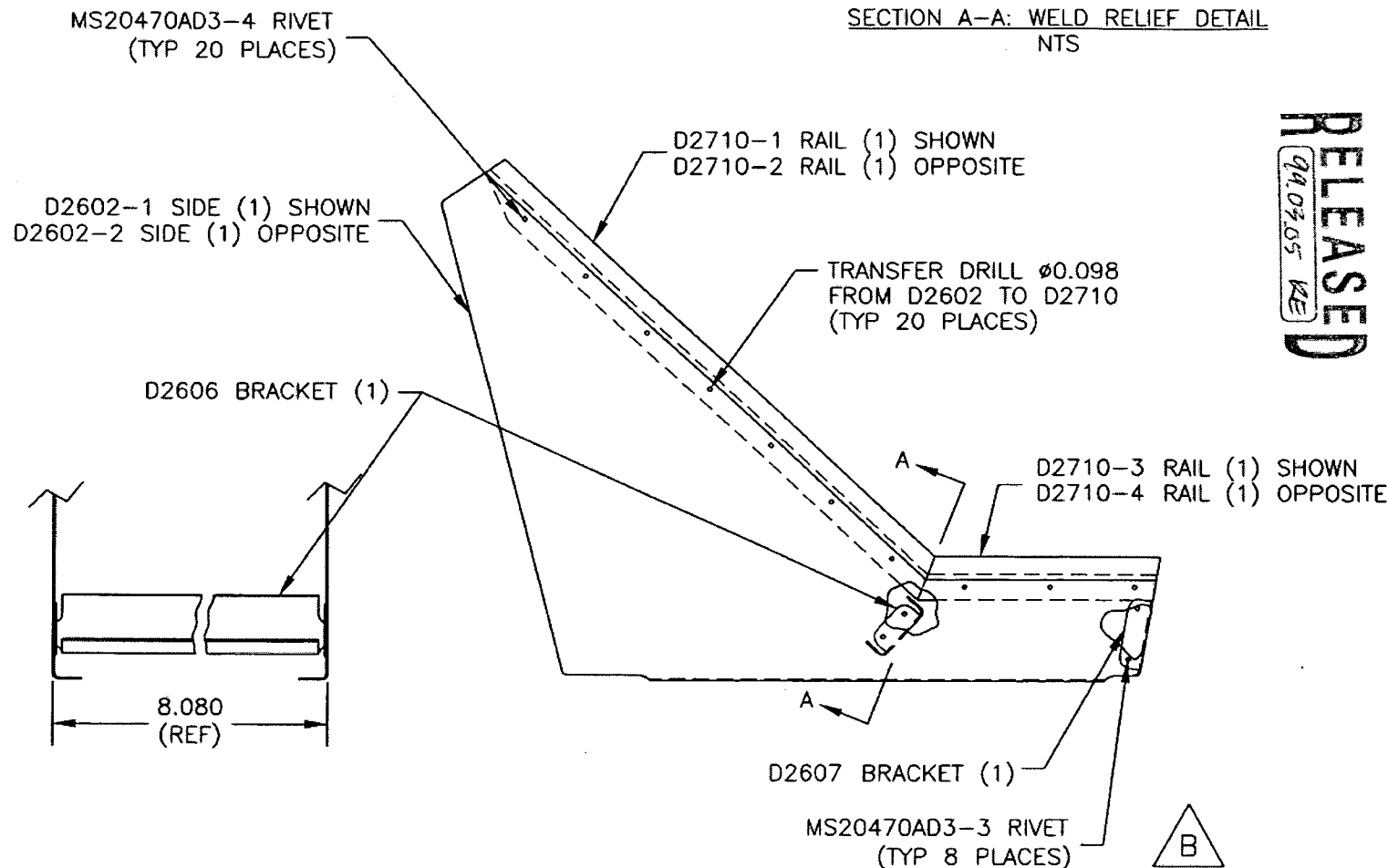
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99.02.05 KE

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DATE	99.02.11	DRAWING NO.	D206-547	REV. F
		TITLE	CONSOLE ASSEMBLY	SHEET 3 OF 5
				SCALE 1:4



GRIND RELIEF
CHAMFER FOR WELD
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SECTION A-A: WELD RELIEF DETAIL
NTS



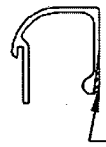
D206-547-043 (206 HIGH SLOPE CONSOLE)

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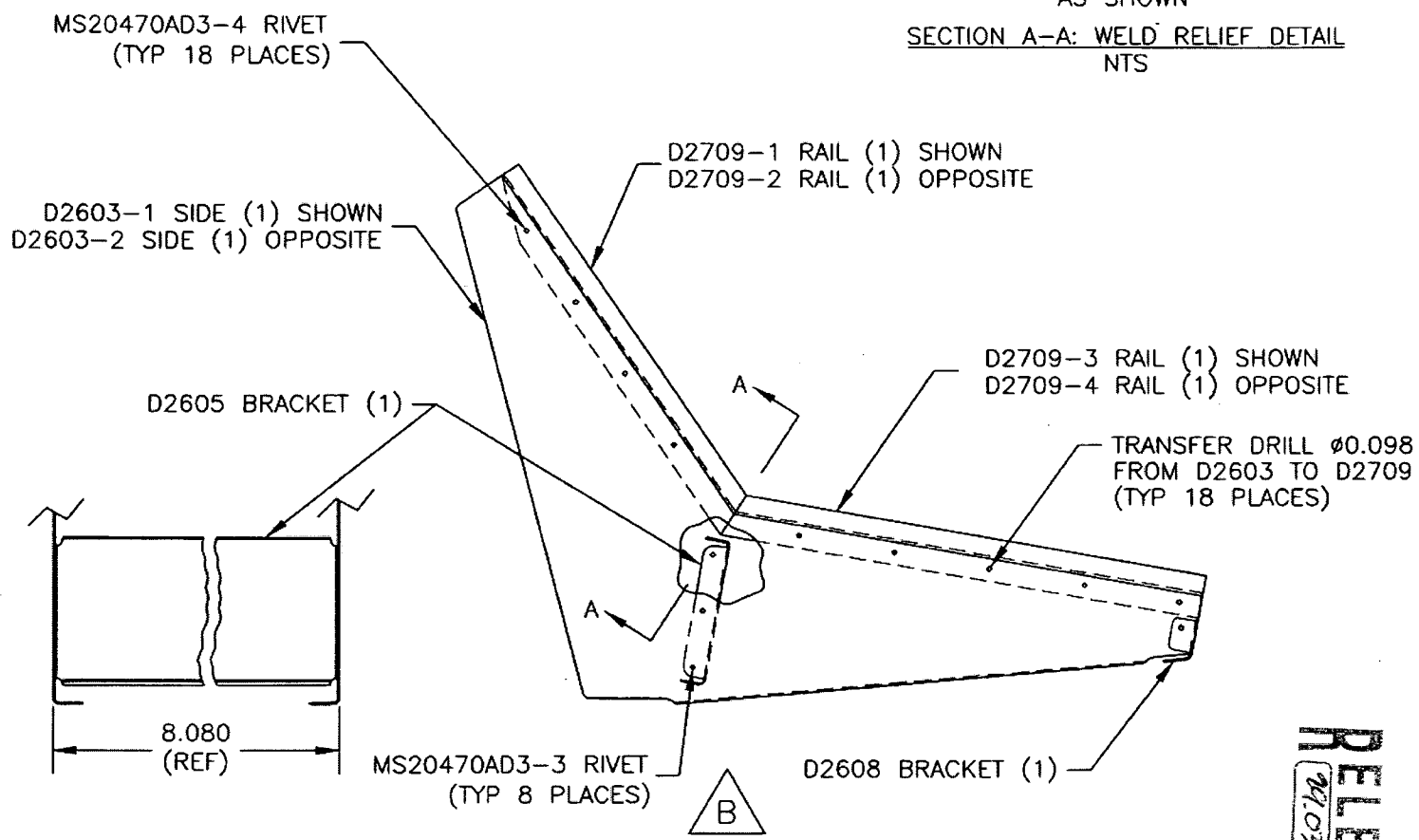
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GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



D407-547-045 (407 LOW SLOPE CONSOLE)

FINISH: POWDER COAT ASSEMBLY MATTE BLACK (4.3.5.4) PER DART QSI 005 4.3
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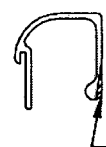
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DATE 99.02.11	TITLE CONSOLE ASSEMBLY	REV. F SHEET 4 OF 5
	SCALE 1:4	

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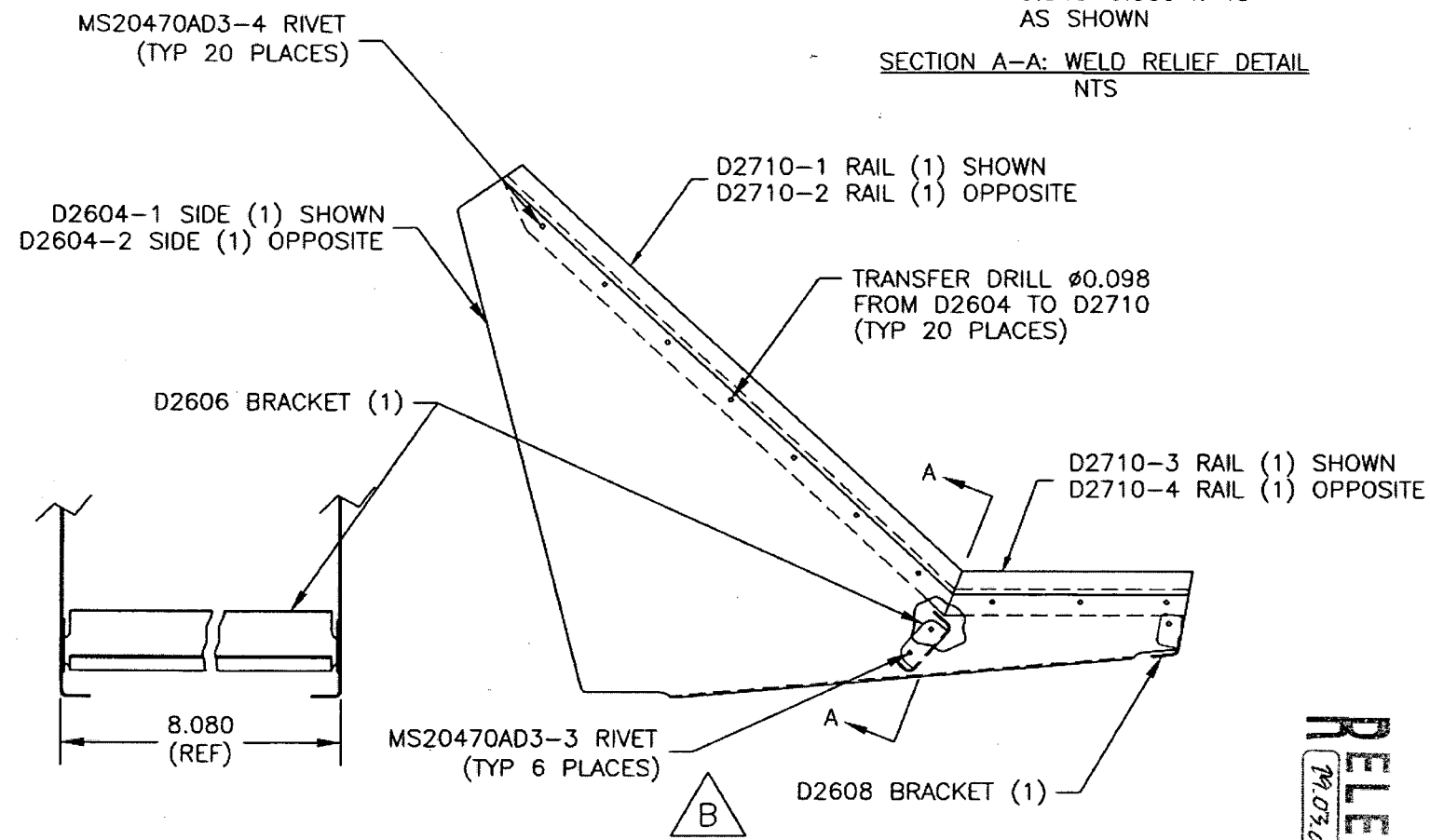
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GRIND RELIEF
CHAMFER FOR WELD
0.040-0.050 x 45°
AS SHOWN

SECTION A-A: WELD RELIEF DETAIL
NTS



RELEASED
19.03.05 KE

DESIGN	BW	DRAWN BY	RF	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA
CHECKED	UP	APPROVED	KE	DRAWING NO. D206-547
DATE	99.02.11	TITLE	CONSOLE ASSEMBLY	REV. F SHEET 5 OF 5
		SCALE	1:4	

D407-547-047 (407 HIGH SLOPE CONSOLE)

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